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603936

647.7401
Job Sheet 179363



Part No: 647.7401

Job Qty: 1 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Stores/Pkg-1		6/19/2018
110	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging1-1		JUL 05 2018
120	Small Fab	1 pcs	6/22/18	6/22/18	0.00	1.09	Small Fab-1		DAS
130	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
140	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1		9-89
150	QC21-SA	1 Ea	6/22/18	6/22/18	0.00	0.00	QC21		21

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCITE JUL 06 2018
Descriptions: 598: exp. date:
140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	5068686
647.7610	Upper Deflector	1 Ea (1 ea)	90-Start up Operation	7138553
647.7810	Bracket A	1 Ea (1 ea)	90-Start up Operation	5078457
647.7811	Bracket B	1 Ea (1 ea)	90-Start up Operation	5084674
647.7812	Center Plate, Upper	1 Ea (1 ea)	90-Start up Operation	5032493
MS21042L08	Use Ms21042L08	13 Ea (13 ea)	90-Start up Operation	5044231
MS21042-3	Nut use MS21042L3	3 Ea (3 ea)	90-Start up Operation	5027548
MS27039-08-19	Screw	6 Ea (6 ea)	90-Start up Operation	5014235
MS27039-08-23	Screw	7 Ea (7 ea)	90-Start up Operation	FM1355230
MS27039-1-19	Screw	3 Ea (3 ea)	90-Start up Operation	5065263
NAS1149F0332P	Washer	6 Ea (6 ea)	90-Start up Operation	5068663
NAS1149FN832P	Washer	68 Ea (68 ea)	90-Start up Operation	FM138336-9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	2	29	0
	647.7610	1	2	0
	647.7810	1	6	0
	647.7811	1	4	0
	647.7812	1	4	0
	MS21042-08	13	0	0
	MS21042-3	3	112	0
	MS27039-08-19	6	865	0

Work Order update only

Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No.		Rework	Scrap	Skid-tube Machining	Cross tube Small Fab	Water Jet	Engineering Quality Other
NCR No.						Prod. Eng. Coord. Tagging	
Date :	St						
Description Work		 DATA AEROSPACE CORP. 270 Aberdeen Street Middletown, OH 46641-1677 OH 46641 TEL: 419.632-6200 Email: sales@datacorp.com www.dataaerospace.com 3089322 Date: 07/05/16					
Root Cause		INSTRUCTIONS: 1. Inspect for damage to the tube. 2. If damaged, replace the tube. 3. If not damaged, proceed to the next step. 4. If the tube is not damaged, inspect for kinks or ripples. 5. If kinks or ripples are found, replace the tube. 6. If no kinks or ripples are found, proceed to the next step. 7. If the tube is not damaged, inspect for cracks. 8. If cracks are found, replace the tube. 9. If no cracks are found, proceed to the next step. 10. If the tube is not damaged, inspect for misalignment. 11. If misalignment is found, replace the tube. 12. If no misalignment is found, proceed to the next step. 13. If the tube is not damaged, inspect for poor information. 14. If poor information is found, replace the tube. 15. If no poor information is found, proceed to the next step. 16. If the tube is not damaged, inspect for use for testing. 17. If use for testing is found, replace the tube. 18. If no use for testing is found, proceed to the next step. 19. If the tube is not damaged, inspect for training. 20. If training is found, replace the tube. 21. If no training is found, proceed to the next step. 22. If the tube is not damaged, inspect for supplier. 23. If supplier is found, replace the tube. 24. If no supplier is found, proceed to the next step. 25. If the tube is not damaged, inspect for offset/setup. 26. If offset/setup is found, replace the tube. 27. If no offset/setup is found, proceed to the next step. 28. If the tube is not damaged, inspect for operator. 29. If operator is found, replace the tube. 30. If no operator is found, proceed to the next step. 31. If the tube is not damaged, inspect for no re-verification. 32. If no re-verification is found, replace the tube. 33. If no re-verification is found, proceed to the next step. 34. If the tube is not damaged, inspect for environment. 35. If environment is found, replace the tube. 36. If no environment is found, proceed to the next step. 37. If the tube is not damaged, inspect for design. 38. If design is found, replace the tube. 39. If no design is found, proceed to the next step. 40. If the tube is not damaged, inspect for doc/data. 41. If doc/data is found, replace the tube. 42. If no doc/data is found, proceed to the next step. 43. If the tube is not damaged, inspect for equip/tooling. 44. If equip/tooling is found, replace the tube. 45. If no equip/tooling is found, proceed to the next step. 46. If the tube is not damaged, inspect for handling/pre. 47. If handling/pre is found, replace the tube. 48. If no handling/pre is found, proceed to the next step. 49. If the tube is not damaged, inspect for material. 50. If material is found, replace the tube. 51. If no material is found, proceed to the next step. 52. If the tube is not damaged, inspect for internal transport. 53. If internal transport is found, replace the tube. 54. If no internal transport is found, proceed to the next step. 55. If the tube is not damaged, inspect for tribal knowledge. 56. If tribal knowledge is found, replace the tube. 57. If no tribal knowledge is found, proceed to the next step. 58. If the tube is not damaged, inspect for LOA. 59. If LOA is found, replace the tube. 60. If no LOA is found, proceed to the next step. 61. If the tube is not damaged, inspect for substation. 62. If substation is found, replace the tube. 63. If no substation is found, proceed to the next step. 64. If the tube is not damaged, inspect for past expiry date. 65. If past expiry date is found, replace the tube. 66. If no past expiry date is found, proceed to the next step. 67. If the tube is not damaged, inspect for misidentified. 68. If misidentified is found, replace the tube. 69. If no misidentified is found, proceed to the next step. 70. If the tube is not damaged, inspect for past due. 71. If past due is found, replace the tube. 72. If no past due is found, proceed to the next step. 73. If the tube is not damaged, inspect for other. 74. If other is found, replace the tube. 75. If no other is found, proceed to the next step. 76. If the tube is not damaged, inspect for marks/chatter. 77. If marks/chatter is found, replace the tube. 78. If no marks/chatter is found, proceed to the next step. 79. If the tube is not damaged, inspect for wave/twist in tube. 80. If wave/twist in tube is found, replace the tube. 81. If no wave/twist in tube is found, proceed to the next step. 82. If the tube is not damaged, inspect for heat treat. 83. If heat treat is found, replace the tube. 84. If no heat treat is found, proceed to the next step. 85. If the tube is not damaged, inspect for crushing. 86. If crushing is found, replace the tube. 87. If no crushing is found, proceed to the next step. 88. If the tube is not damaged, inspect for cuffs. 89. If cuffs is found, replace the tube. 90. If no cuffs is found, proceed to the next step. 91. If the tube is not damaged, inspect for crimp/kink/ripple/wave. 92. If crimp/kink/ripple/wave is found, replace the tube. 93. If no crimp/kink/ripple/wave is found, proceed to the next step. 94. If the tube is not damaged, inspect for cracks. 95. If cracks are found, replace the tube. 96. If no cracks are found, proceed to the next step. 97. If the tube is not damaged, inspect for centre not concentric. 98. If centre not concentric is found, replace the tube. 99. If no centre not concentric is found, proceed to the next step. 100. If the tube is not damaged, inspect for BOM/route. 101. If BOM/route is found, replace the tube. 102. If no BOM/route is found, proceed to the next step. 103. If the tube is not damaged, inspect for broken/damage/defect. 104. If broken/damage/defect is found, replace the tube. 105. If no broken/damage/defect is found, proceed to the next step. 106. If the tube is not damaged, inspect for inspection incomplete/unqualified. 107. If inspection incomplete/unqualified is found, replace the tube. 108. If no inspection incomplete/unqualified is found, proceed to the next step. 109. If the tube is not damaged, inspect for contamination. 110. If contamination is found, replace the tube. 111. If no contamination is found, proceed to the next step. 112. If the tube is not damaged, inspect for countersink. 113. If countersink is found, replace the tube. 114. If no countersink is found, proceed to the next step. 115. If the tube is not damaged, inspect for cut too short. 116. If cut too short is found, replace the tube. 117. If no cut too short is found, proceed to the next step. 118. If the tube is not damaged, inspect for instructions incomplete/unclear. 119. If instructions incomplete/unclear is found, replace the tube. 120. If no instructions incomplete/unclear is found, proceed to the next step. 121. If the tube is not damaged, inspect for drill holes. 122. If drill holes are found, replace the tube. 123. If no drill holes are found, proceed to the next step. 124. If the tube is not damaged, inspect for misaligned/off center. 125. If misaligned/off center is found, replace the tube. 126. If no misaligned/off center is found, proceed to the next step. 127. If the tube is not damaged, inspect for grain. 128. If grain is found, replace the tube. 129. If no grain is found, proceed to the next step. 130. If the tube is not damaged, inspect for weld. 131. If weld is found, replace the tube. 132. If no weld is found, proceed to the next step. 133. If the tube is not damaged, inspect for wrong stock pulled. 134. If wrong stock pulled is found, replace the tube. 135. If no wrong stock pulled is found, proceed to the next step. 136. If the tube is not damaged, inspect for out of sequence. 137. If out of sequence is found, replace the tube. 138. If no out of sequence is found, proceed to the next step. 139. If the tube is not damaged, inspect for off-set. 140. If off-set is found, replace the tube. 141. If no off-set is found, proceed to the next step. 142. If the tube is not damaged, inspect for mislabeled. 143. If mislabeled is found, replace the tube. 144. If no mislabeled is found, proceed to the next step. 145. If the tube is not damaged, inspect for fit/function. 146. If fit/function is found, replace the tube. 147. If no fit/function is found, proceed to the next step. 148. If the tube is not damaged, inspect for turning sequence. 149. If turning sequence is found, replace the tube. 150. If no turning sequence is found, proceed to the next step. 151. If the tube is not damaged, inspect for misread. 152. If misread is found, replace the tube. 153. If no misread is found, proceed to the next step. 154. If the tube is not damaged, inspect for finish. 155. If finish is found, replace the tube. 156. If no finish is found, proceed to the next step. 157. If the tube is not damaged, inspect for drawing. 158. If drawing is found, replace the tube. 159. If no drawing is found, proceed to the next step. 160. If the tube is not damaged, inspect for part moved. 161. If part moved is found, replace the tube. 162. If no part moved is found, proceed to the next step. 163. If the tube is not damaged, inspect for part lost/missing. 164. If part lost/missing is found, replace the tube. 165. If no part lost/missing is found, proceed to the next step. 166. If the tube is not damaged, inspect for part incorrect. 167. If part incorrect is found, replace the tube. 168. If no part incorrect is found, proceed to the next step. 169. If the tube is not damaged, inspect for over/under tolerance. 170. If over/under tolerance is found, replace the tube. 171. If no over/under tolerance is found, proceed to the next step. 172. If the tube is not damaged, inspect for outside dimensions. 173. If outside dimensions is found, replace the tube. 174. If no outside dimensions is found, proceed to the next step. 175. If the tube is not damaged, inspect for positioned wrong. 176. If positioned wrong is found, replace the tube. 17					

MS27039-08-23	7	30	0
MS27039-1-19	3	391	0
NAS1149F0332P	6	1,710	0
NAS1149FN832P	68	1,429	0

Part Specifications

Specifications could not be found.

Plex 6/18/18 11:33 AM Dart.lajeunesse.marie